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D2279**Job Sheet 198924****Part No:** D2279**Job Qty:** 60 pcs**Part Name:** Step Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/7/19**Job Tracking No:****Due Date:** 8/14/19**Created By:** Jason Leroux**Type:** SOLD**Description:****Note:** DWG REV D IPP Rev: A New Issue 05-11-07 JLM IPP Rev: B Now on Waterjet 06-07-03 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	60 pcs		8/14/19	0.17	3.19	Waterjet - Flow		JRB 8/14/19
120	QC 8	60 pcs		8/14/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
125	Small Fab - 2 - B4B	60 pcs		8/14/19	0.00	1.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		

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					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
130	Small Fab - Brake NC - B4B	60 pcs	8/14/19	0.25 0.60	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	AUG 16 2019
140	QC 5	60 pcs	8/14/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	AUG 16 2019
					QC 5 - 61	
					QC 5 - 81	
150	Handfinish - 1-1 Chemical-B4B	60 pcs	8/14/19	0.00 1.27	Handfinish - 1 - 1 - B4B	BEB 19-08-19.
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	QC 7	60 pcs	8/14/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	

					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	SMB
					QC 7 - 59	19/8/19
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
170	Packaging 3-1 - Stock - B4B	60 pcs	8/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	SMB
					Packaging 3 - 8 - B4B	19/8/19
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	60 pcs	8/14/19	0.00 0.00	QC 21 - SA - 21	DAS 21 AUG 19 2019
					QC 21 - SA - 70	AUG 20 2019

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9-89

QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg
 Descriptions: 120 - (QC8- Inspect parts - second check)
 125 - FORM FLANGE AS PER DWG USING DT8174
 130 - Bend as per Dwg D2279
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - QC7-Inspect Chemical Conversion Coat)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	8.8200 sf (.147 ea)	100-Waterjet - Flow - 1	5191572

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	9	158	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	0.250Inches ± 0.005	0.255 0.245	0.247	
2	Step Spacer	2.214Inches ± 0.005	2.219 2.209	2.215	
3	Step Spacer	4.178Inches ± 0.005	4.183 4.173	4.179	
4	Step Spacer	4.428Inches ± 0.010	4.438 4.418	4.427	
5	Step Spacer	0.250Inches ± 0.005	0.255 0.245	2.51	
6	Step Spacer	1.313Inches ± 0.005	1.318 1.308	1.316	
7	Step Spacer	3.313Inches ± 0.005	3.318 3.308	3.315	
8	Step Spacer	4.625Inches ± 0.010	4.635 4.615	4.628	
9	Step Spacer	0.128Inches + 0.005 - 0.000	0.133 0.128	0.130	Diameter
10	Step Spacer	1.250Inches + 0.005 - 0.000	1.255 1.250	1.251	Diameter
11	Step Spacer	0.125Inches ± 0.010	0.135 0.115	0.125	Radius

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Container No: S205618



Part: D2279

Job No: 198924

Serial No/Batch: S205618

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/14/19